

Tuesday, 18/11/2008 8:46:27 AM

Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE AFT
 Job Number : 43518
 Estimate Number : 12486
 P.O. Number :
 This Issue : 18/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : CROSSTUBES
 Previous Run : 43517
 Part Number : D350748201up
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 05/12/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JD 08-11-18
 Comment :
 Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update qty of MS21042L5 06-09-12 KJ
 Est Rev C Combined manufacturing 08.04.02 EC verified by:
 DD
 Est Rev:D 08-06-24 revD as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



for JD 08/12/08



Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001

8 09/01/01

2.0

D350748241TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

patch: *B43679*

DP 9-2-2

3.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

DP 9-2-2

4.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

for 02-03 @

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

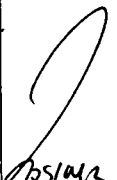
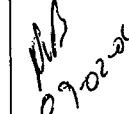
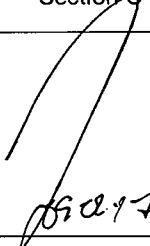

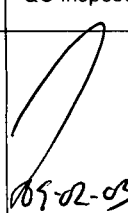
2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,

Set-up drill table as per QSI 010

AWM 9-2-4
MB 090204
P70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 UP PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 05/04/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 43518		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-02-03	5.0	Side B is slightly higher than A, by 0.125". i.e. bend process.		Trim cuff 'B' to the mark w/ line to have an even height. Drill 2 nominal.	 09/02/04			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 8:46:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 43518

Part Number: D350748201ul

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

4-Engrave Part # and Batch # as per Dwg D350-748-241

Aw m 9-2-4
MB 09-02-03

6.0

QC6

DIMENSIONAL CHECK



Note: PTO on previous page.



Comment: DIMENSIONAL CHECK

208217 (1)

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8213

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C209/02/118

(1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

209/3/13 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

Prime only do not paint
assemble primed only

AT
09-03-16

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

S 0203/17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 8:46:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 43518

Part Number: D350748201 *WP*

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D2856400	Abraison Strip
------	----------	----------------



10/11 Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

RT 09-03-18

13.0	ALS41032225	Insert
------	-------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 19393

RT 09-03-18

14.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 110523

RT 09-03-18

15.0	MS2192020	Clamp (per MIL-DTL-8783C)
------	-----------	---------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 110451

RT 09-03-18

16.0	MS27039110	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 110704

RT 09-03-18

17.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

RT 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 8:46:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 43518

Part Number: D350748201

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 QC5

INSPECT WORK TO CURRENT STEP



INSPECTED FOR FLATNESS
ACCEPT TABLE 09.03.25



Comment: INSPECT WORK TO CURRENT STEP

09/03/38

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

20.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
350 SADDLE
Batch: 36016

21.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SUPPORT
Batch: 41603

RT 09-03-18

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
BUSHING
Batch: B39726

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt
Batch: M108558

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
bolt
Batch: M109068

9/3/31

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 8:46:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 43518

Part Number: D350748201

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN532A	Bolt
------	--------	------



S Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M109752

76

26.0	AN960JD416	Washer
------	------------	--------



S Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer
Batch: M109249

50

27.0	AN960JD516	Washer
------	------------	--------



S Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer
Batch: M109752

50

28.0	MS21042L4	Nut
------	-----------	-----



S Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Nut
Batch: M108145

56

29.0	MS21042L5	Nut
------	-----------	-----



S Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: M109297

9/13/13

56

30.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

809/04/01

31.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location: _____

PPP Rev: _____

Rev A

809/04/01

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 8:46:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 43518

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/06 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

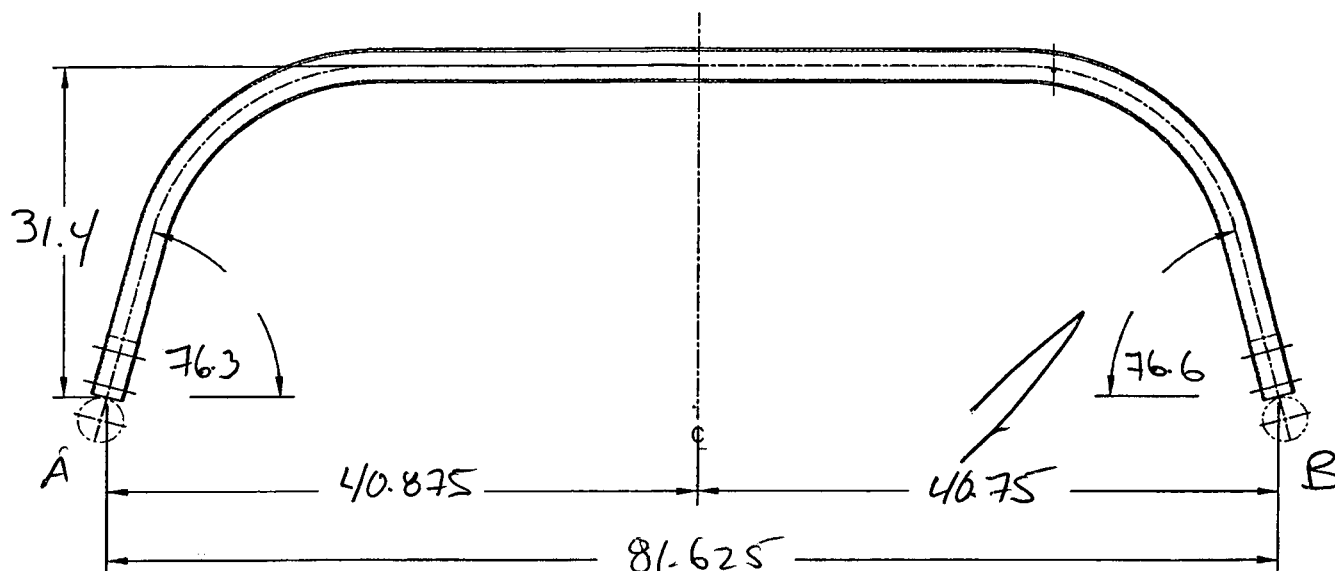
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43518
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
Trim 0.125 off of side B to match side A
MAX DIST = 0.576" ACCEPTABLE 09.03.25

QC15 Inspection	
Date	05.02.03

SUBMITTED
 REVIEWED
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT OF CHANGE
 WORK ORDER
 NO. 43518

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

DART**RELEASED**

06.10.31

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>///</i>	APPROVED <i>///</i>	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

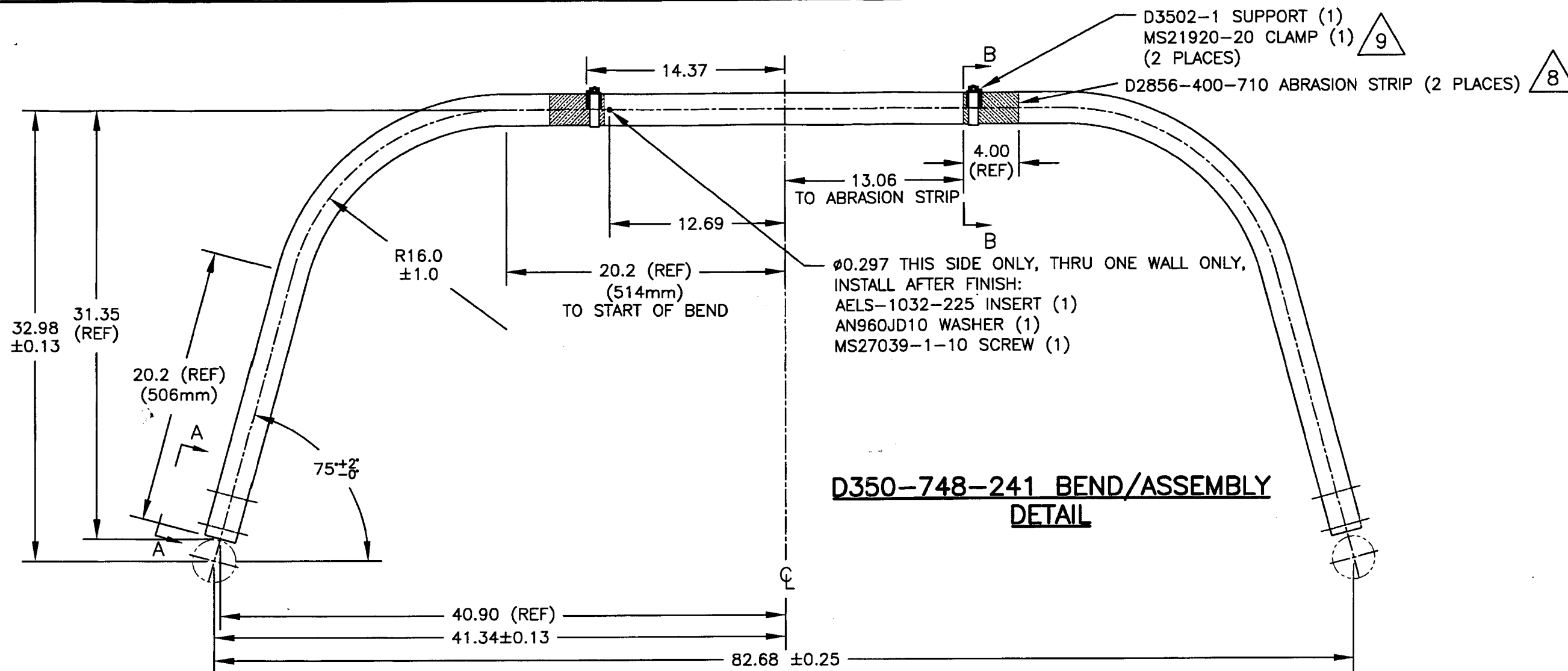
07.02.16

CUT FOR REDUCED

CP 07.11.22

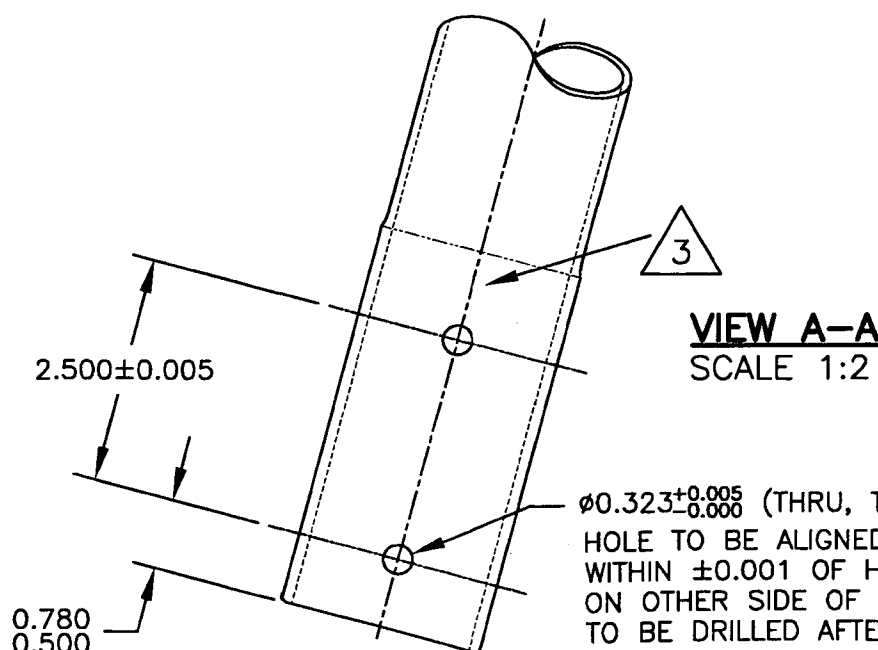
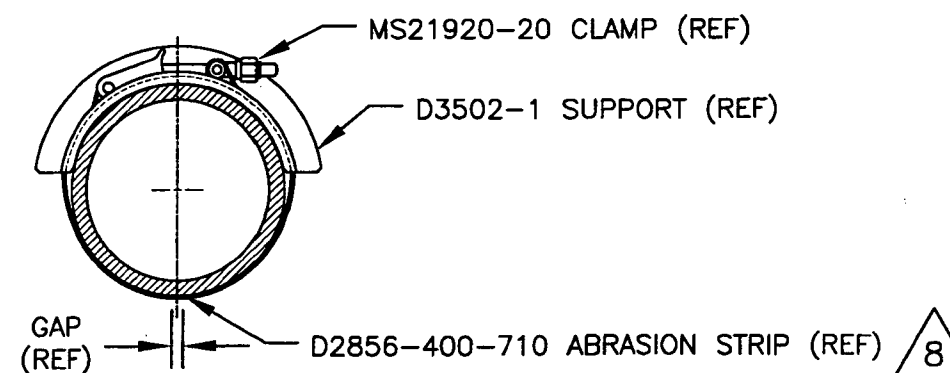
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D350-748-241 BEND/ASSEMBLY DETAIL

SECTION B-B SCALE 1:2



KEEP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
NO TO AMENDMENT
ALL CHANGES
NOTED
43518

UNDER REVIEW

07.02/16/17

CUFF BEND REDUCED
OK 07.07.22

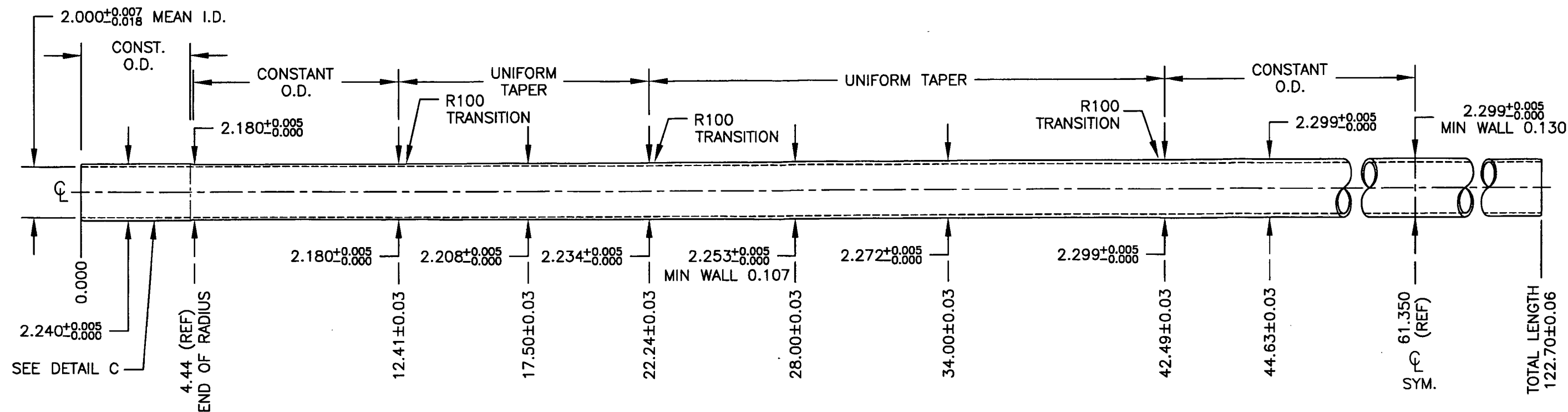
RELEASED

06.10.31

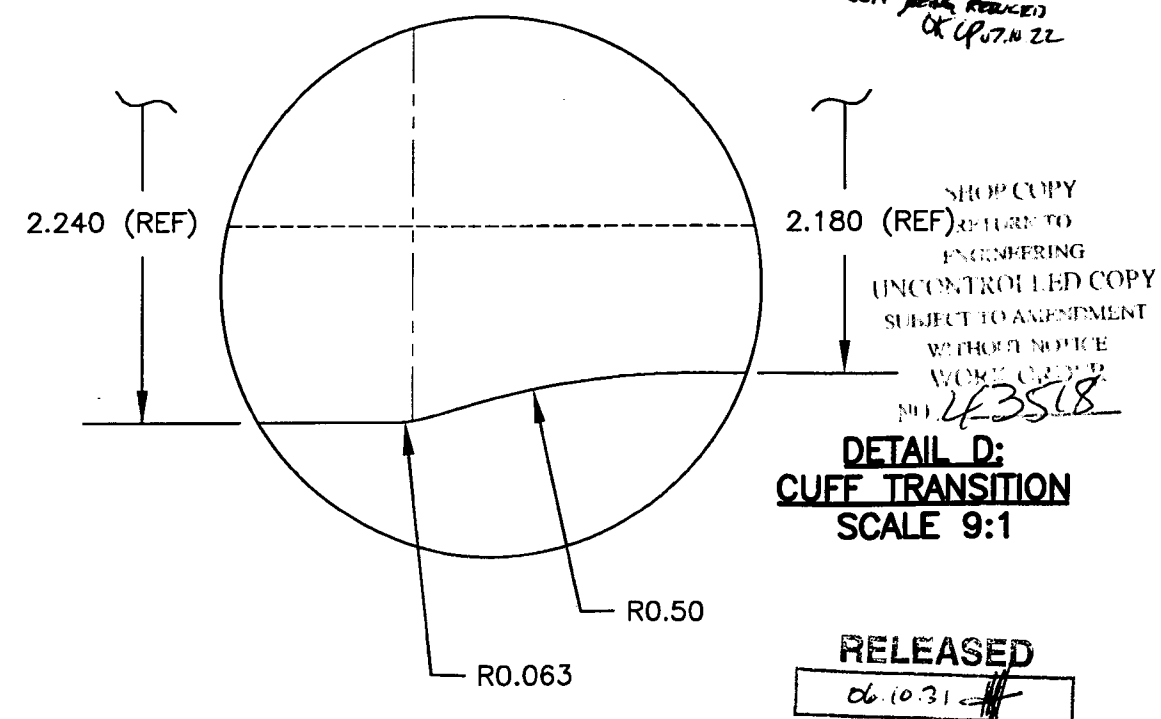
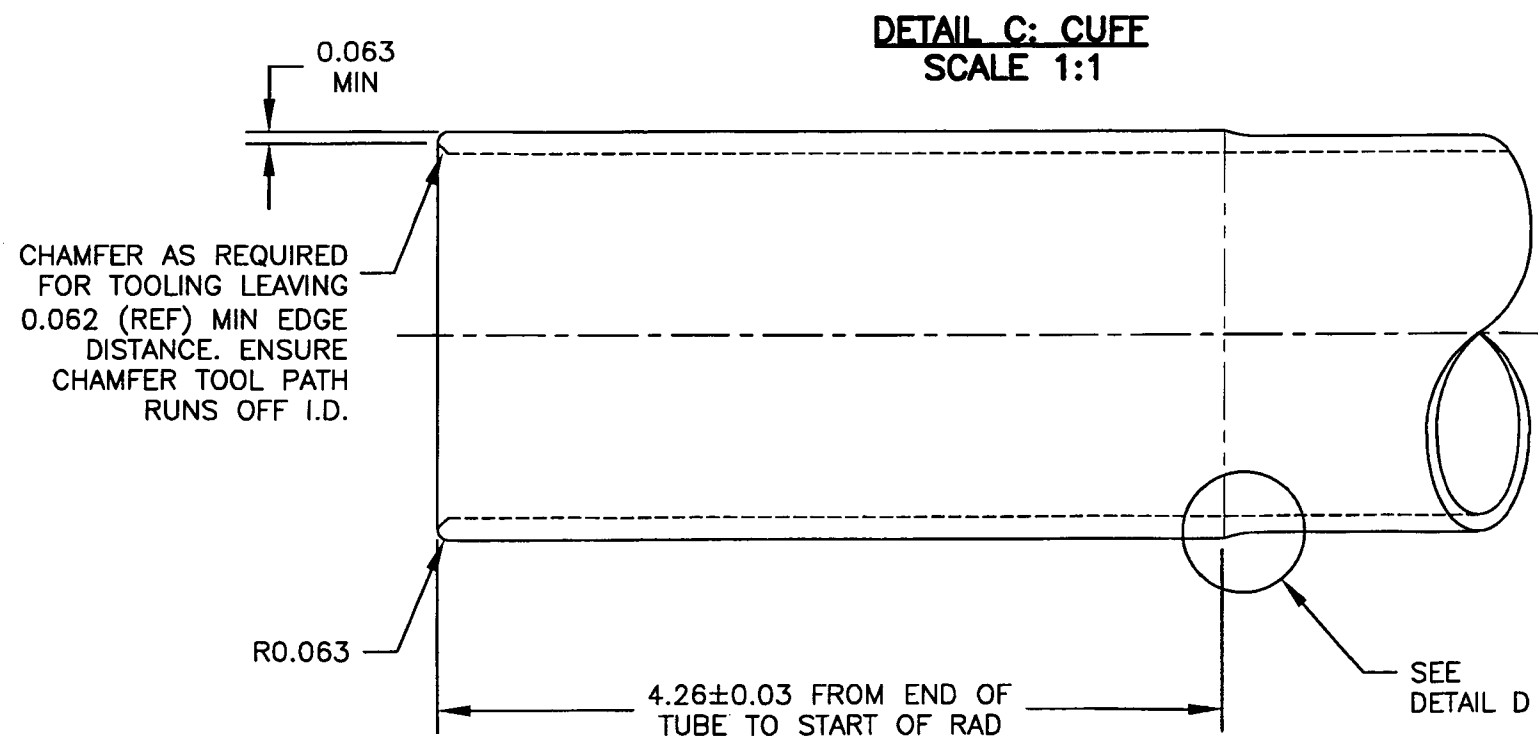
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DESIGN	q	DRAWN BY	q	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI AFT)	D350-748-241	SHEET 2 OF 3
		SCALE	1:8		



D350-748-241 MACHINING DETAIL



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DESIGN qp	DRAWN BY qp	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Mar-09-2009

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 84232
INVOICE #: 43414

**CONTRACT OR
PURCHASE ORDER #**

PO00008213

DESCRIPTION: SKID

QTY 1

P/N # D350-748-201 ✓

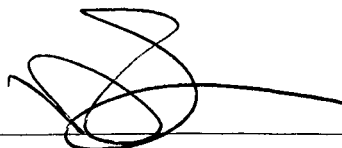
S/N # B43518

**STRESS RELIEF BAKE @ 375 DEG. FOR 5 HRS HEAT CHART
#10182. MPI INSPECTED IAW ASTM-E-1444. CADMIUM PLATED IAW
AMS-QQ-P-416B, TYPE 2 YELLOW, CLASS 2. BAKE HEAT CHART
#10219.**



**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:



Date: Tuesday, 31/03/2009 12:49:17 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number :	42537	Customer :	Dart Helicopters Services				
Estimate Number :	12486	DWG Name :	350/355 AS X-TUBE AFT				
Purchase Order # :		Part Number :	D350748201				
Complete Date :	18/12/2008 1:31:24	DWG Number :	N/A				
		Rev. :	D				

DUE DATE		ORDERED		DELIVERED	
22/10/2008	1			1	

2.0 D350748241TRN-Crosstube Turning Detail								INVENTORY IT
DATE	EMPLOYEE	TYPE	Qty		COST			
18/12/2008	LACE01: Lacelle, Linda	D350748241TRN	1.000		\$419.50	Lot # 40413 Qty. 1		
Subtotal:		QTD:	1	CTD:	0	\$419.50		

3.0 BENDING								Internal Operation
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost	
19/11/2008	PAQU03: Paquette, Dan	Run	1.000	0.34	\$6.46	0.34	14.47	
19/11/2008	BRUN01: Brunet, Marc	Run	1.000	0.36	\$6.84	0.36	15.32	
Subtotal:		QTD:	2	CTD:	0	0.70	\$43.09	

5.0 CROSSTUBES								Internal Operation
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost	
19/11/2008	BRUN01: Brunet, Marc	Run	1.000	2.29	\$43.49	2.29	107.42	
20/11/2008	MAHE01: Maheu, Andrew	Run	1.000	1.01	\$16.32	1.01	40.31	
21/11/2008	TITL01: Titley, Ian	Run	1.000	0.10	\$1.62	0.58	23.14	
Subtotal:		QTD:	3	CTD:	0	3.40	\$232.30	

7.0 OUTSIDE SERV.11								Sub-contr./External OP.
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAVO01: Lavoie, Chantal	IN	1.000		\$500.00			
Subtotal:		QTD:	0	CTD:	1	\$500.00		

10.0 SPRAY PAINTING								Internal Operation
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost	
16/12/2008	MURD02: Murdoch, Matthew	Run	0.000	0.37	\$5.98	1.46	57.32	
16/12/2008	MURD02: Murdoch, Matthew	Run	1.000	0.65	\$10.50	2.59	101.70	
Subtotal:		QTD:	1	CTD:	0	1.02	\$175.50	

12.0 D2856400-Abraison Strip								INVENTORY ITEM
DATE	EMPLOYEE	TYPE	Qty		COST			
18/12/2008	LACE01: Lacelle, Linda	D2856400	1.240		\$5.10	Lot # 37667 Qty. 1		
Subtotal:		QTD:	1	CTD:	0	\$5.10		

13.0 ALS41032225-Insert								INVENTORY ITEM
DATE	EMPLOYEE	TYPE	Qty		COST			
18/12/2008	LACE01: Lacelle, Linda	ALS41032225	1.000		\$0.17	Lot # 100489 Qty. 1		
Subtotal:		QTD:	1	CTD:	0	\$0.17		

14.0 AN960JD10-Washer								INVENTORY ITEM
DATE	EMPLOYEE	TYPE	Qty		COST			
18/12/2008	LACE01: Lacelle, Linda	AN960JD10	1.000		\$0.06	Lot # 109061 Qty. 1		
Subtotal:		QTD:	1	CTD:	0	\$0.06		

REFERENCE ONLY

Date: Tuesday, 31/03/2009 12:49:17 PM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number :	42537	Customer :	Dart Helicopters Services		
Estimate Number :	12486	DWG Name :	350/355 AS X-TUBE AFT		
Purchase Order # :		Part Number :	D350748201		
Complete Date :	18/12/2008 1:31:24	DWG Number :	N/A	Rev. :	D

15.0 MS2192020-Clamp (per MIL-DTL-8783C) INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
18/12/2008	LACE01: Lacelle, Linda	MS2192020	2.000		\$29.90	Lot # 109715 Qty. 2	
Subtotal:		QTD:	2	CTD:	0	\$29.90	

16.0 MS27039110-Screw INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
18/12/2008	LACE01: Lacelle, Linda	MS27039110	1.000		\$0.10	Lot # 18836 Qty. 1	
Subtotal:		QTD:	1	CTD:	0	\$0.10	

17.0 CROSSTUBES Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
17/12/2008	TITL01: Titley, Ian	Run	1.000	0.46	\$7.43	0.46	18.35
17/12/2008	TITL01: Titley, Ian	Run	1.000	0.18	\$2.91	0.18	7.19
Subtotal:		QTD:	2	CTD:	0	0.64	\$35.88

20.0 D35001-Saddle INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
17/12/2008	QUIR01: Quirion, Sonia	D35001	4.000		\$581.14	X Lot # 36016 Qty. 4	
Subtotal:		QTD:	0	CTD:	4	\$581.14	

21.0 D35021-Support INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
18/12/2008	LACE01: Lacelle, Linda	D35021	2.000		\$62.82	41603 Lot # 42968 Qty. 2	
Subtotal:		QTD:	2	CTD:	0	\$62.82	

22.0 D35011-Bushing INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
17/12/2008	QUIR01: Quirion, Sonia	D35011	16.000		\$59.37	X Lot # 39726 Qty. 16	
Subtotal:		QTD:	0	CTD:	16	\$59.37	

23.0 AN46A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
17/12/2008	QUIR01: Quirion, Sonia	AN46A	16.000		\$2.44	X Lot # 108558 Qty. 16	
Subtotal:		QTD:	0	CTD:	16	\$2.44	

24.0 AN441A-bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
17/12/2008	QUIR01: Quirion, Sonia	AN441A	8.000		\$11.50	X Lot # 109068 Qty. 8	
Subtotal:		QTD:	0	CTD:	8	\$11.50	

25.0 AN532A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
17/12/2008	QUIR01: Quirion, Sonia	AN532A	4.000		\$4.78	X Lot # 109752 Qty. 4	
Subtotal:		QTD:	0	CTD:	4	\$4.78	

Date: Tuesday, 31/03/2009 12:49:18 PM
 User: Linda Tacelle

JOB HISTORY : DETAIL

Job Number	: 42537	Customer	: Dart Helicopters Services
Estimate Number	: 12486	DWG Name	: 350/355 AS X-TUBE AFT
Purchase Order #	:	Part Number	: D350748201
Complete Date	: 18/12/2008 1:31:24	DWG Number	: N/A
		Rev.	: D

26.0 AN960JD416-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
17/12/2008	QUIR01: Quirion, Sonia	AN960JD416	32.000	\$0.99	Lot # 109249 Qty. 32
Subtotal:			QTD: 0 CTD: 32	\$0.99	

27.0 AN960JD516-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
17/12/2008	QUIR01: Quirion, Sonia	AN960JD516	8.000	\$0.39	Lot # 109752 Qty. 8
Subtotal:			QTD: 0 CTD: 8	\$0.39	

28.0 MS21042L4-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
17/12/2008	QUIR01: Quirion, Sonia	MS21042L4	24.000	\$5.08	Lot # 108145 Qty. 24
Subtotal:			QTD: 0 CTD: 24	\$5.08	

29.0 MS21042L5-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
17/12/2008	QUIR01: Quirion, Sonia	MS21042L5	4.000	\$2.39	Lot # 109297 Qty. 4
Subtotal:			QTD: 0 CTD: 4	\$2.39	

		TIME	COST
	Machine Time:	9.27	\$385.22
	Labor:	5.76	\$101.55
	Sub-contract (external Op.):		\$500.00
	INVENTORY ITEM:		\$1185.73
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$2172.50

COST PER UNIT: \$2172.50